

Work Order ID 69902

Tuesday, May 24, 2011 12:57:02 PM



Page 1

Item ID:	D3536-23	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Gasket					
Start Date:	5/24/2011	Start Qty:	16.00		Cust Item ID:	
Required Date:	5/31/2011	Req'd Qty:	16.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-05-24	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3536	Rev A								

100		FLOW WATER JET	0.00						
	Waterjet	Memo	0.00						
	FLOW CNC Waterjet	1-Cut as per Dwg D3536 <input checked="" type="checkbox"/> Dwg Rev: <u>A</u> <input type="checkbox"/> Prog Rev: <u>A</u> <input type="checkbox"/> 2-Debur if necessary							
									<u>HB11-6-8</u>
110		QC2- Inspect parts off machine FAI/FAIB	0.00						
	QC	Memo	0.00						
	Quality Control								<u>HB11-6-8</u>
120		QC8- Inspect parts - second check	0.00						
	QC	Memo	0.00						
	Quality Control								
									<u>count</u> <u>+26</u>

(26)

Subtotal

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69902

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Page 2

Item ID: D3536-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 5/24/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00				11/6/09		26	
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/6/09 MF 11-06-09	

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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 12:57:10 PM

Page 1

Work Order ID: 69902

Parent Item: D3536-23

Parent Item Name: Gasket





Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	189.1800	1.3365	23.76	26 40.		
NEOPRENE SHEET 0.063											B11-6-8		

Location

Loc Qty

Loc Code

MAT052

189.18

117295

189.18

117295

26

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	69902
Description: Gasket		Part Number:	D3536-23
Inspection Dwg: D3536	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.85	+/-0.030	52.85	✓		T	IBOT
48.20	+/-0.030	48.20	✓		T	
44.70	+/-0.030	44.70	✓		T	
39.31	+/-0.030	39.31	✓		T	
33.92	+/-0.030	33.92	✓		T	
28.53	+/-0.030	28.53	✓		T	
23.14	+/-0.030	23.14	✓		T	
17.75	+/-0.030	17.75	✓		T	
14.25	+/-0.030	14.25	✓		T	
9.50	+/-0.030	9.50	✓		T	
4.75	+/-0.030	4.75	✓		T	
8.00	+/-0.030	8.00	✓		T	
16.00	+/-0.030	16.00	✓		T	
24.00	+/-0.030	24.00	✓		T	
32.00	+/-0.030	32.00	✓		T	
39.00	+/-0.030	39.00	✓		T	
48.00	+/-0.030	48.00	✓		T	
0.30	+/-0.030	-307	✓		V	IBOT
0.30	+/-0.030	-304	✓		V	
1.89	+/-0.030	1.887	✓		V	
Ø0.19	+0.005/-0.001	-190	✓		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-6-0	Date: 06/06/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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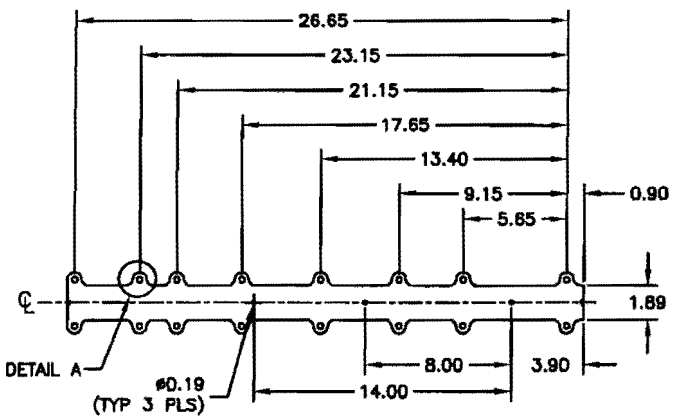
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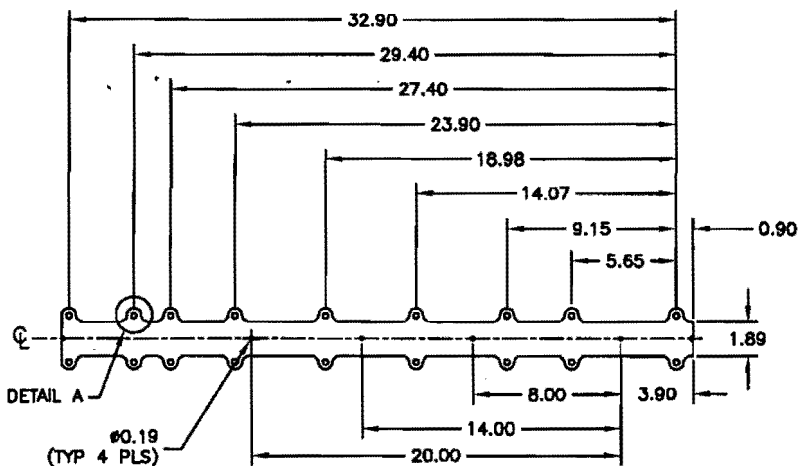
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69902

PL11-05-24



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	CB	PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 1 OF 6	SCALE 1:10
A	06.10.25	NEW ISSUE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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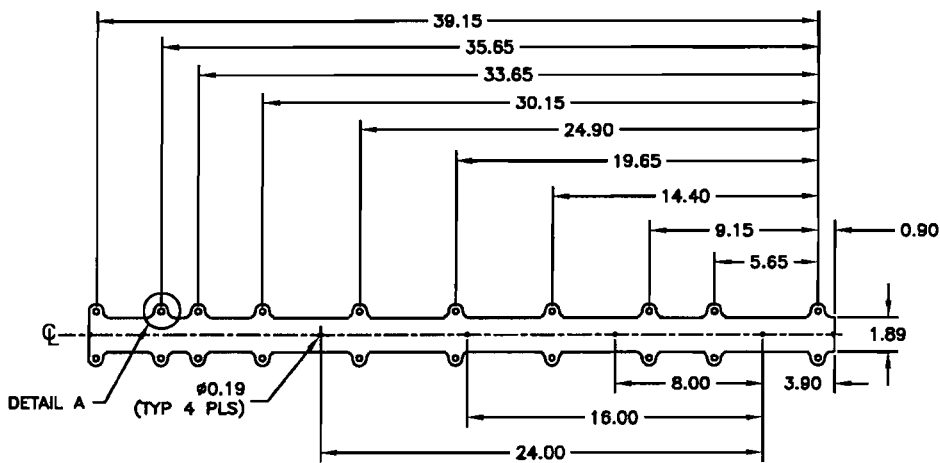
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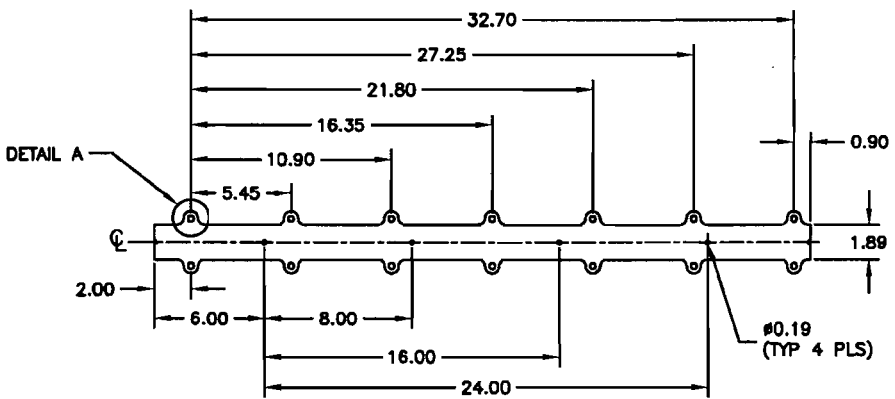
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA	
DATE	06.10.25	TITLE	D3536	DRAWING NO.	REV. A
		GASKET			SHEET 2 OF 6
					SCALE 1:10

RELEASED
07.02.12

W/C 69922



D3536-15 GASKET



D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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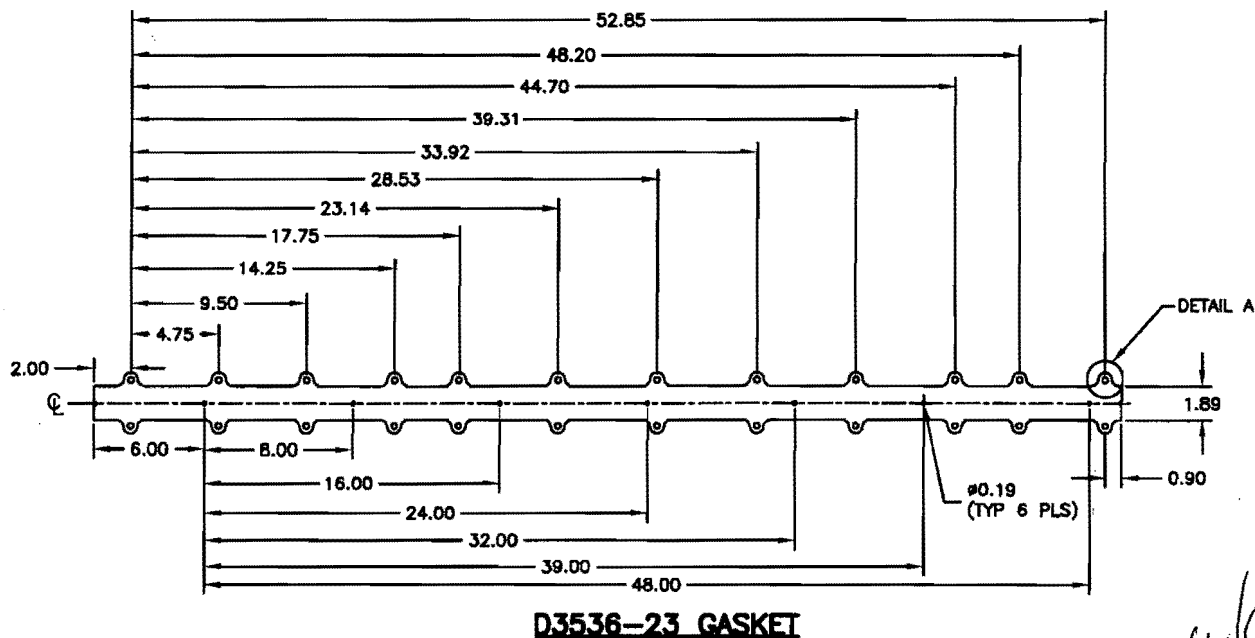
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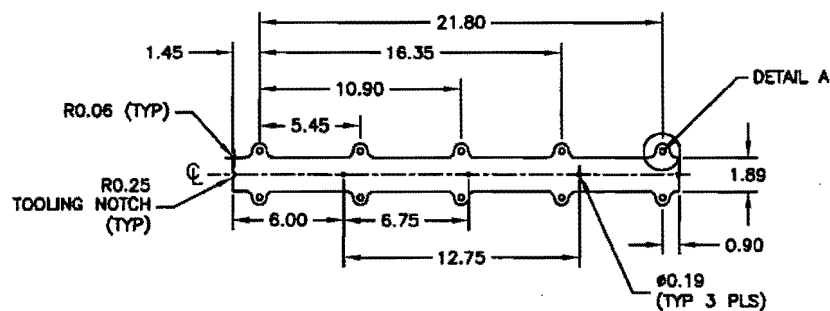
NOTE: Date & initial all entries

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. A
CB	CB	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 3 OF 6
AM	AM	D3536	
DATE	TITLE	SCALE	
06.10.25	GASKET	1:10	

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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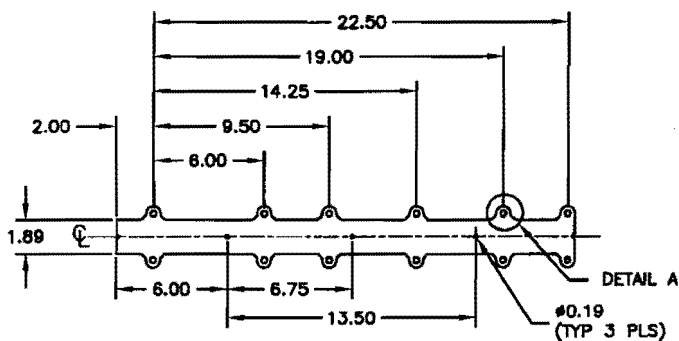
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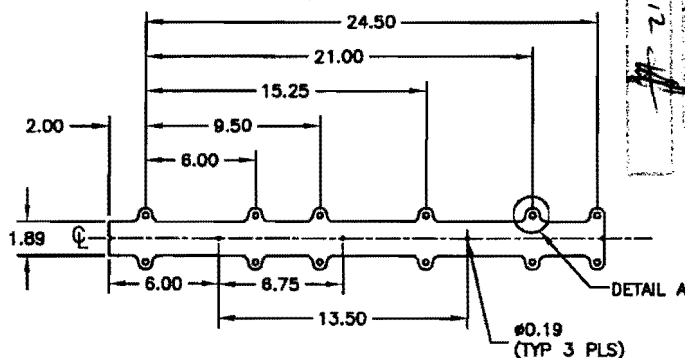
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CHECKED	AH	APPROVED	AH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	GASKET	REV. A
		DRAWING NO.	D3536	SHEET 4 OF 6
		SCALE	1:10	

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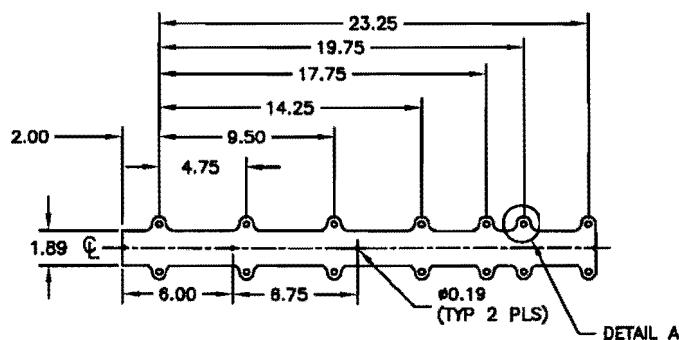


D3536-31 GASKET



D3536-33 GASKET

W/069902



D3536-35 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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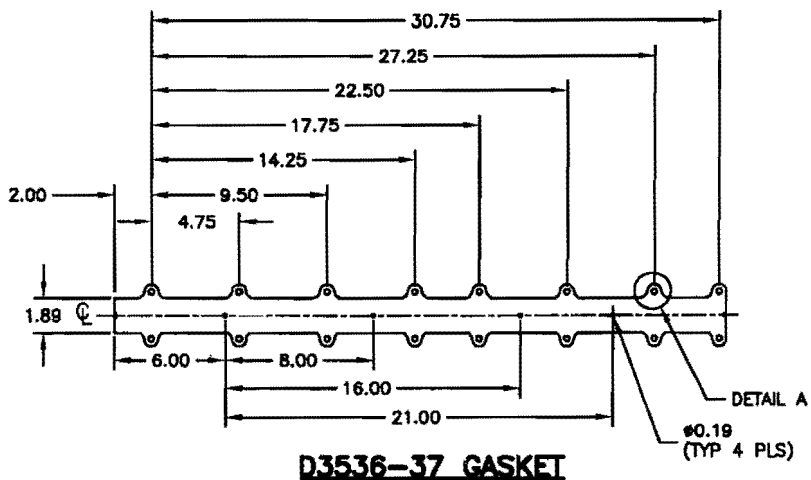
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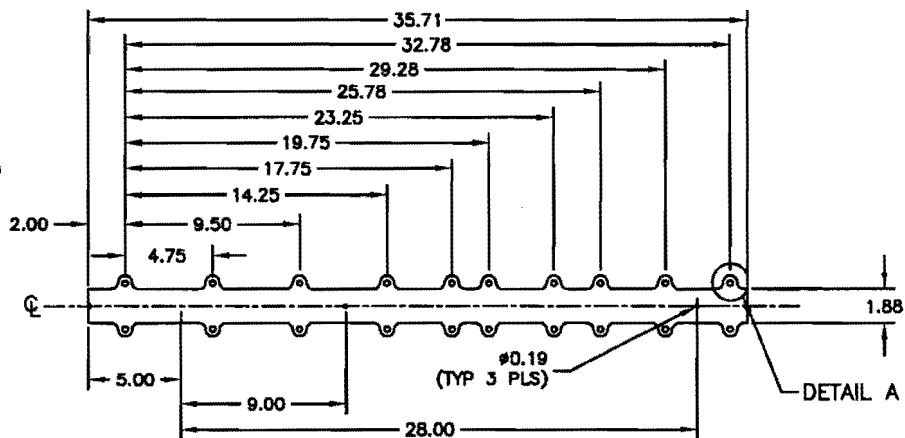
DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	PH	APPROVED	PH	
DATE	06.10.25	TITLE	D3536	REV. A
		GASKET		SHEET 5 OF 6
				SCALE 1:10

07.02.12
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07.02.12

u1069902



D3536-37 GASKET



D3536-39 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 80 DUROMETER (REF DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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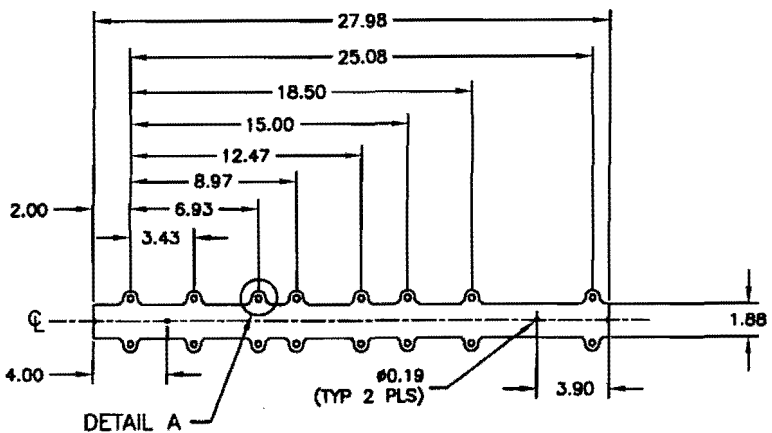
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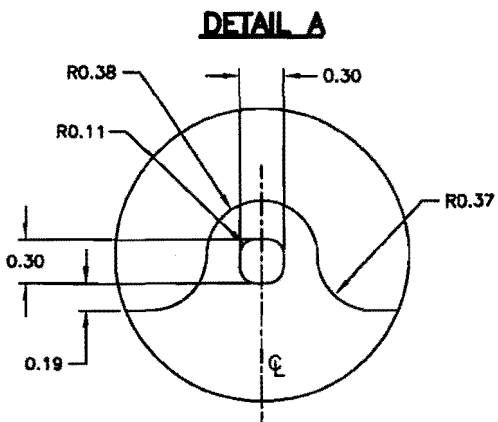
DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE USA, INC.	
PORT HADLOCK, WA					
CHECKED	PH	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. A
				D3536	SHEET 6 OF 6
DATE				TITLE	SCALE
06.10.25				GASKET	1:10

07-22-12



D3536-41 GASKET

WLB 69902



10153

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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